

Ship May 30

119317

May-15-14 2:55:40 PM

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 5/15/14 **Start Qty:** 10.00

10

Cust Item ID:

Required Date: 5/15/14 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: MCS Date: 14-05-15 Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D2480 Rev A1

100

0.00

100

Large Fab

Large Fab

Memo

0.00

Large Fab

Weld as per Template DT 8333 (DT 2480 CJ)

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00

110

QC

Memo

0.00

Quality Control

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.00

Quality Control

DAS
9
9.89

DAS
9
9.89

Work Order ID 119317

May-15-14 2:55:40 PM

119317

Page 2

Item ID: D2480-012 Accept *N900040100* Setup Start *NS1*

Revision ID: Stop *NS2*

Item Name: Heli-Access Handle Weldment RH

Start Date: 5/15/14 Start Qty: 10.00 *10* Cust Item ID:

Required Date: 5/15/14 Req'd Qty: 10.00 *10* Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Powdercoat Powder Coating	White Gloss(Ref:4.3,5.2) per QS:005 4.3-Steel M 128959. Memo START TIME: 10:35 OVEN TEMPERATURE: 2:00 FINISH TIME: 11:05.	0.00 0.00				9 -	φ 14-63.		DAS 34 9-89
140 *140* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				9			DAS 27 9-89 14/6/13
150 *150* Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo PRP 119313	0.00 0.00				9	14/6/13		DAS 32 1-89

Work Order ID 119317

May-15-14 2:55:40 PM

119317

Page 3

Item ID: D2480-012 Accept *N900040100* Setup Start *NS1*

Revision ID: Stop *NS2*

Item Name: Heli-Access Handle Weldment RH

Start Date: 5/15/14 Start Qty: 10.00 *10* Cust Item ID:

Required Date: 5/15/14 Req'd Qty: 10.00 *10* Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

MLJ 140603

MF 14-6-3

May-15-14 2:55:43 PM

119317

D2480-012

Start Date: 5/15/14

Required Date: 5/15/14

Start Qty: 10.00

Required Qty: 10.00

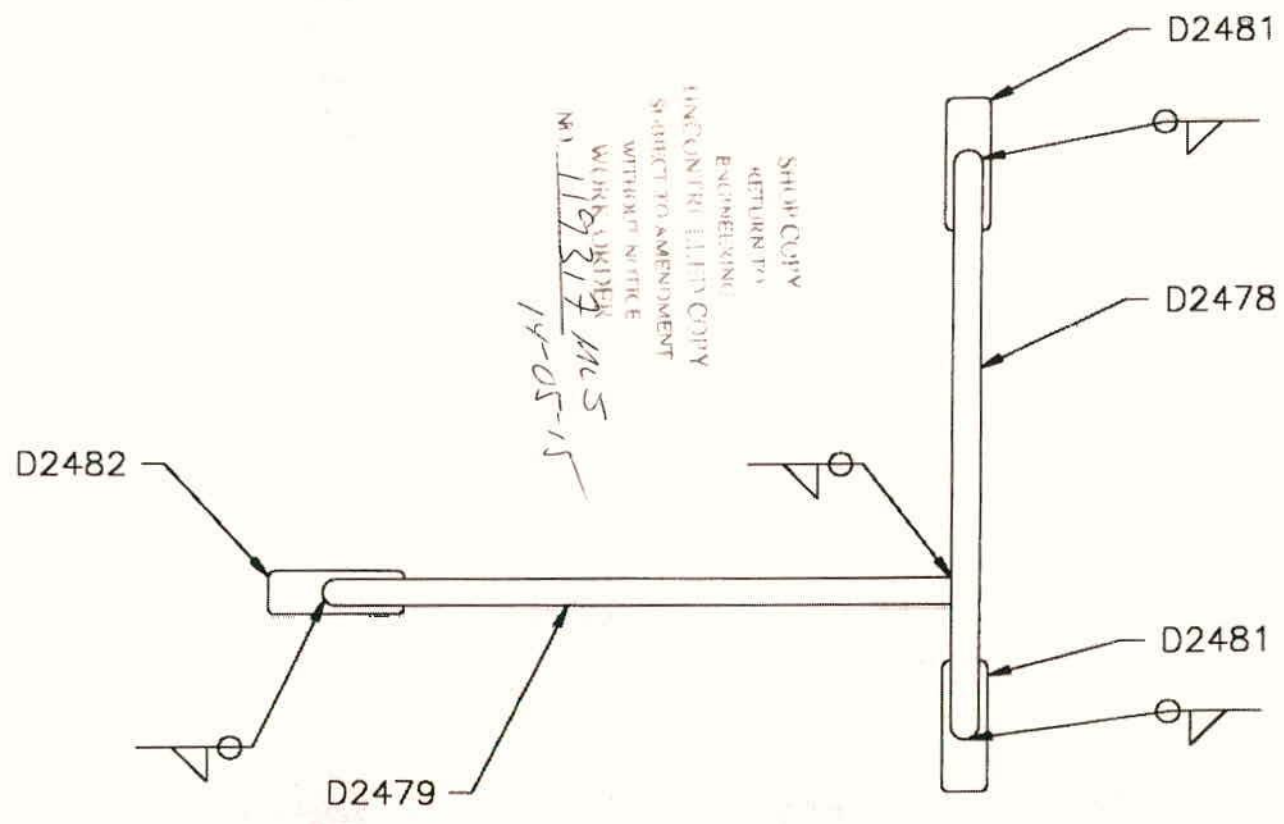
Comments: IPP C1 03.01.09 Added Powder Coat

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2478 *D2478* Heli-Access Handle		Manufactured	No			100	Each	0.0000	1	10			
				117848 x 8		2x 119314			**			12/14-5-26	
D2479 *D2479* Heli-Access Handle		Manufactured	No			100	Each	0.0000	1	10			
				117827 x 8		2x 119315			**			12/14-5-26	
D2481 *D2481* Mounting Plate		Manufactured	No			100	Each	17.0000	2	20			
									**			12/14-5-28	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA002		17							
				119318 x 4		7							
				76081		10							
				90003									
D2482 *D2482* Mounting Plate		Manufactured	No			100	Each	32.0000	1	10			
									**			12/14-5-28	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA002		32							
				38319		32							



DESIGN	DRAWN BY	DART AEROSPACE LTD	
B WILLIAMS	MIKE M	VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
<i>BW</i>	<i>BW</i>	D2480	SHEET 1 OF 1
DATE	TITLE		SCALE
96:05:14	HANDLE WELDMENT ASSEMBLY		8:1
A1 11/05.06.23		ADDED POWDER COAT	

RELEASED
96/10/02 DS



D2480-011 LH SHOWN
D2480-012 RH OPPOSITE

NOTES:

- 1) WELD PER TEMPLATE DT 2480 WG PER QSI 004
- 2) POWDER COAT WHITE GLOSS (REF: 4.3.5.2) AS PER QSI 005